

Work Order ID 55233

January 12, 2010 1:30:09 PM



Page 1

Item ID: D4044-5

Accept



Setup Start



Revision ID:

Item Name: Aft Rib

Stop



Start Date: 1/12/10 Start Qty: 1.00



Cust Item ID:

Required Date: 1/25/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: *PL*

Date: *10-1-12*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D4044

PA1 PA3 10/01/27

100

0.00



Large Fab

Memo

0.00

Large Fab

1- Cut tube 60" and remove identification markings
2- Bend tube with manuel pipe bender as per dwg D4044
3- Trim access tube material to finish size as per dwg D4044

MATERIAL CERTIFICATION
REQ'D UPON DELIVERY

PD 10.01.26

110

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

=> 10/01/26

(+1)

120

Identify as per dwg & Stock Location: *Basket*

0.00



Packaging

Memo

0.00

Packaging

PD 10.01.26

PRELIMINARY ISSUE

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 55233

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Item ID: D4044-5

Accept



Setup Start



Revision ID:

Stop



Item Name: Aft Rib

Start Date: 1/12/10 Start Qty: 1.00



Cust Item ID:

Required Date: 1/25/10 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

*Prototype
10.01.30*

*mk
10-1-27*

POSITIVE RECALL
EFFECTIVE 10.01.27 AUTH U
RELEASED _____ DATE _____

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 1

January 12, 2010 1:30:13 PM

Work Order ID: 55233



Parent Item: D4044-5



Parent Item Name: Aft Rib

Start Date: 1/12/10

Required Date: 1/25/10

Comments: IPP RevA: new issue DD 10/01/05 verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304TS0.750W.049		Purchased	No			100	f	48.4054	52632	18.633		Use some For Template



304 SQ Tube .75x.75x.049W

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

48.4054

103240

1.5816

106604

4.9307

107460

29.2779

109087

12.6152

M113763

PD 10.01.26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	55233
Description: <i>Bending Template</i>		Part Number:	A4044-S
Inspection Dwg: <i>A4044</i>	Rev: <i>PA3</i>	Page 1 of 1	

☒ **First Article** ☐ **Prototype**

[illegible]

Measured by:	<i>M</i>	Audited by:	<i>S</i>	Prototype Approval:	N/A
Date:	<i>10/01/26</i>	Date:	<i>10/01/26</i>	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

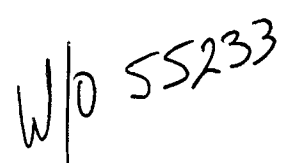
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 2.21 lbs
- 8) TUBE FLAT LENGTH 59.31 REF
- 9) ALLOWABLE DAMAGE IN BENDS ?" DEEP, TYPICAL

D4044-5 AFT RIB

PRELIMINARY ISSUE

~~10~~ 10.01.18

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. PA3
MFG. APPR.		D4044	SHEET 5 OF 5
APPROVED		TITLE	SCALE
DE APPR.		RIB ASSEMBLY	NTS
DATE	10.01.18	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT	



Magna Stainless
5775 Kieran St, Saint-Laurent QC H4S 0A3
Phone: (514) 339-1211 Watts: 1-800-363-6646 Fax: (514) 339-1105

INVOICE

Pg 1 of 1 I022188

SOLD TO:

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY , ON
K6A 1K7

SHIP TO:

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY , ON
K6A 1K7

MTR:Y

INVOICE DATE: 01/25/10

ORDER DATE: 01/19/10

SHIP DATE: 01/25/10

ORDER NUMBER: W024119

PURCHASE ORDER: P011060

Currency	Sales Person	Ship Via	F.O.B.	Terms
CANADIAN DOLLARS	ERYCK BLAIS	NIR:R-557065-1	PREPAID	NET 30 DAYS

Ln	Back Ordered	Ordered	Unit	Description	Shipped	Price Per	Value
		15	PC	STAINLESS - FT 304 MF 3/4" SQ X .049 X 20' L035630 15 PC/300 FT	15 UN	65.00	975.00

RECEIVED JAN 28 2010

01/26/10 13:25:05

PST Exmp No:EXEMPT

Merchandise:	975.00
Surcharges:	
No Tax Costs:	
GST	48.75
Total Due:	1,023.75

Title to the goods sent out on this invoice remains with Magna Stainless Div of CSM ULC until such time as this invoice has been paid in full. Unless otherwise noted terms are 30 days. Interest accrues on all overdue accounts at the rate of 1.5% per month compounded monthly.

Q.S.T. # 1213236471
G.S.T. # 881565899 RT0001

Jan 25 10 01:56p

002/002

p.3

PHOENIX TUBE COMPANY, INC.
Manufacturer of Stainless Ornamental and Structural Tubing

CERTIFICATION OF TEST

Sold To: MAGNA STAINLESS INC.
5775 RUE KIERAN

SAINT-LAURENT
CAN

QC H4S

Ship To: MAGNA STAINLESS INC.
5775 RUE KIERAN

SAINT-LAURENT
CAN

QC H4S

CUSTOMER ORDER#: PO08691

DATE SHIPPED: 02/23/10

SIZE: 3/4SQ X 18 GA AW

SOURCE: USA D

VENDOR: NAS

Specification:

ASTM A554-08a

NO WELD REPAIR

Phone# 3391211

ORDER#: 209402

QTY SHIPPED: 300.0

GRADE: 304

HEAT#: 3DK8

TEST REPORT#: TR007424

Report Date: 11/28/07

Ext:

WELD: HF

WELDED / MILL-FINISH

OK P 10.01.26

PO08691

MERCURY IS NOT USED BY US AS AN ALLOYING MATERIAL NOR IS METALLIC MERCURY HANDLED IN THE VICINITY OF OUR PROCESSING LINES. WE ARE NOT PRESENTLY AWARE OF ANY MERCURY CONTAMINATION.

Chemical Analysis

C	MN	P	S	SI	CR	NI	MO	CU	CO	N2
.058	1.564	.028	.015	.267	18.363	8.14	.256	.298	0	.042

Physical Analysis

Hardness	YIELD		TENSILE		OTHER	
	PSI	MPA	PSI	MPA	Percent EL	Percent RA
RB 86	49780	0	99490	0	54.1	0

THE CHEMICAL ANALYSES ARE CORRECT AS CONTAINED IN OUR CORPORATE RECORDS.
PHYSICAL PROPERTIES ARE DETERMINED WHILE MATERIAL IS IN STRIP FORM.

Melted & Manufactured in the USA FAR BAA complies, DFARS BAA complies, FAR TAA complies

CERTIFIED BY:

Janet Lerao

1185 WIN DR, BETHLEHEM, PA., 18017 - (610) 865-5337
FAX NUMBER: 610-865-4073

Sq. mill finish